



NUMBER: 23-028-12

GROUP: Body

DATE: September 14, 2012

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SUBJECT:

Headliner May Droop 1/4"(6mm) to 1/2"(13mm) At The Rear Edge Of Power Sunshade Opening

OVERVIEW:

This bulletin involves modifying the headliner and adding two sets of dual lock fasteners to secure the headliner at the roof panel.

MODELS:

2011-2012 (LC) Challenger

SYMPTOM/CONDITION:

Headliner may droop 1/4" (6mm) to 1/2" (13mm) at the rear edge of the sunshade opening.

DIAGNOSIS:

While sunroof is open, wind may cause the headliner to sag at the rear edge of the sunshade opening. If the customer describes the symptom, perform the Repair Procedure.

PARTS REQUIRED:

Qty.	Part No.	Description
2 (AR)	68164134AA	Fastener, Dual Lock
1 (AR)	NPN	Duramix 4747 Super Fast Adhesive Or Equivalent
1 (AR)	NPN	3M 06396 Adhesion Promoter Wipe Or Equivalent
2 (AR)	NPN	3M 4909 3M Duramix 4747 Mixing Tips Or Equivalent
1 (AR)	NPN	Isopropyl Alcohol

NOTE: One 50 ml cartridge of Duramix 4747 will approximately service 12 vehicles.

REPAIR PROCEDURE:

1. Is the headliner sagging at the area identified in (Fig. 1)?
 - a. Yes >>> Proceed to [Step #2](#).
 - b. No >>> Continue further diagnosis, this bulletin does not apply.

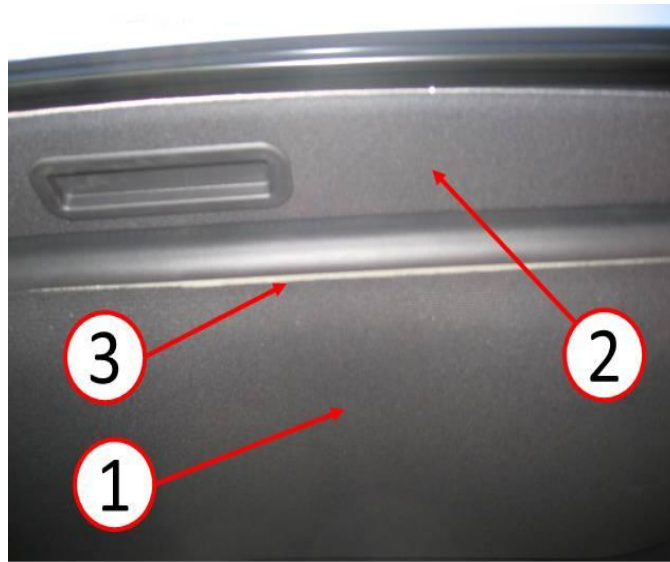


Fig. 1 Headliner Gap

- 1 - Headliner
- 2 - Sunroof Sunshade
- 3 - Headliner Gap

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2. Remove the seal (welt) around the sunroof opening.
 3. Lower the headliner at the area of the sag in order to gain access to the backside of the headliner.
 4. Remove the white fiberglass scrim from the backside of the headliner where the dual lock fastener from the repair kit will be bonded ([Fig. 2](#)).

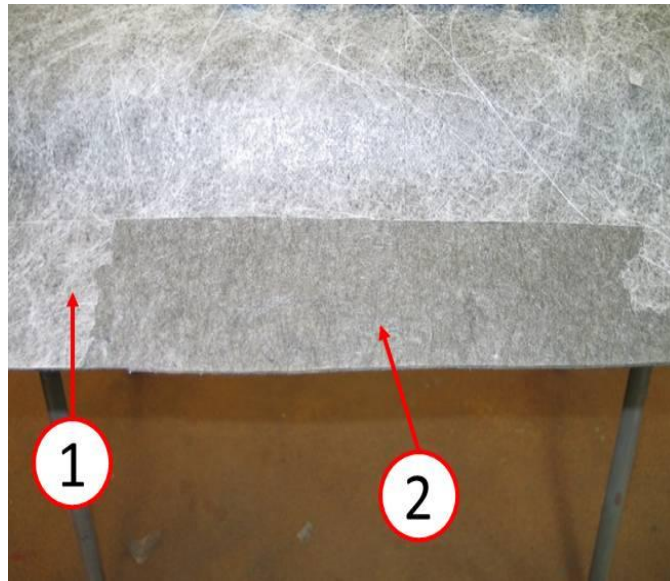


Fig. 2 Scrim Removal

- 1 - Scrim
- 2 - Scrim Removed

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5. Sand the back of the smooth plastic dual lock fasteners with 80 grit sandpaper and once clean, apply adhesion promoter.

NOTE: Dual lock fasteners must be rotated 90 degrees to aid in future removal.

6. Apply 3M Duramix 4747 or equivalent to the now sanded surface of the dual lock fastener that will be bonded to the headliner with the other dual lock clip attached as shown in (Fig. 3).

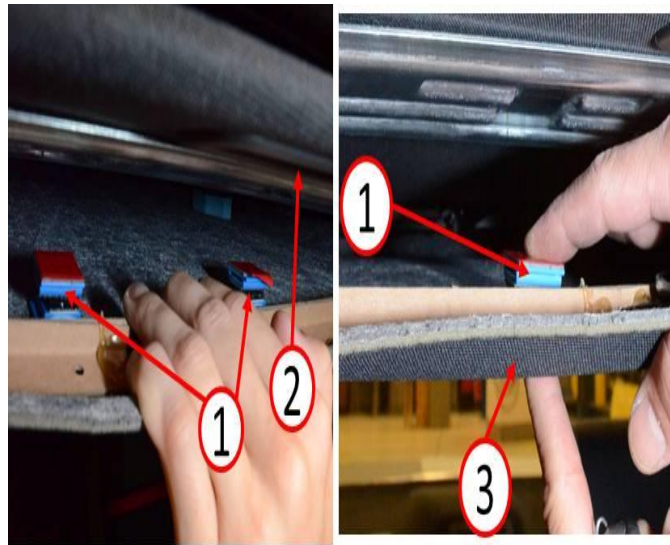


Fig. 3 Setting The Fastener

- 1 - Dual Lock Fastener
- 2 - Headliner Grab Handle
- 3 - Headliner

NOTE: Install one fastener at a time, as the adhesive will set in 20 seconds.

NOTE: Apply slight pressure to the dual lock fastener and hold in place for 30 seconds to ensure a good bond and repeat for the other clip(Fig. 3). Allow adhesive to cure for 5 minutes .

7. Clean the surface area of the roof panel where the dual lock fastener will be adhered with isopropyl alcohol and a lint free rag.
8. Remove the red adhesive liner from the dual lock fastener and firmly press the headliner against the roof to wet out the adhesive on both dual lock fasteners for 10 seconds.
9. Reinstall the seal (welt) around the sunroof opening on the metal flange.

POLICY:

Reimbursable within the provisions of the warranty.

TIME ALLOWANCE:

Labor Operation No:	Description	Amount
23-20-45-96	Inspect Headliner Only (Skill Level = B, Training Level = 2)	0.2 Hrs.
23-20-45-97	Inspect and Modify Headliner (Skill Level = B, Training Level = 2)	0.3 Hrs.

FAILURE CODE:

ZZ	Service Action
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